

Work Order ID 50129

July 8, 2009 11:50:05 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

100



Large Fab

Large Fab

Memo

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

D2512

Rev E

0.00

Large Fab

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 2-Cut (4) D2236 From
D3166-3 Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
 5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as
required

31/07/2009 M109213

SAD 09.07.09 ①

110



QC9- Inspect visual per QSI004- Fusion Welds

QC

Quality Control

0.00

Memo

0.00

09.07.14

09.07.14 1x

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Item ID: D2512

Accept

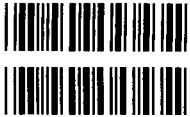


Setup Start



Revision ID: E

Stop



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Start Date: 7/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling:

Date: _____

Run Start



QC:

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

⇒ So 07/14

Draw
Number

Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo PRESSURE WASH

0.00

09-07-14 (OK)

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

COAT: START TIME: 7:30AM 400°F OVEN TEMPERATURE:

7:50AM FINISH TIME: 8:00AM 1ST 2ND

COAT: START TIME: 8:30AM OVEN TEM 400°F 1112148 09-07-15 (OK) 90

140



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M111013

UMP 09/07/16 (OK)

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Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

BL09-07-16

0.00

Memo

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

50082

0.00

W

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/21 JJ

U 09.07.17

Picklist Print

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Page 1

Work Order ID: 50129



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC		Manufactured	No			100	Each	12.0000	2.0000			

Basket Hinge

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

12

48230

12

32x

SY 09/07/13

D2327-1RevD



Manufactured No

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

20

46325

20

2x

SY 09/07/13

D2506RevF



Manufactured No

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

5

44275

1

48607

4

1x

SY 09/07/13

Label Plate

Picklist Print

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Work Order ID: 50129



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	35.0000	2.0000			

Mounting Bracket

Warehouse

Location

Main Warehouse

ST 35

46086 2

48428 33

D3166-3RevA1

Manufactured

No

Basket Hoop

M304EX0.75-16F

Purchased

No

Expanded Metal Flat SS

Warehouse

Location

Main Warehouse

MAT 818.0437

108152 90

110134 6.7

110292 14.4

110629 14.41

110861 21.18

110992 0.58

111444 17.79

111630 35.15

111956 36.36

112147 581.4737

2x 8/09/07/13
SAO 09-07-14

2.00
16.00
SAO 09-07-09 ①

Picklist Print

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Parent Item: D2512RevE



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Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	463.0861	45.8741			

304 SQ Tube .75x.75x.065W



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	463.0861	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	25.14	
112051	416.2961	
		5.00
		40.8741

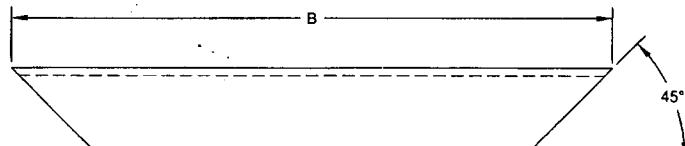
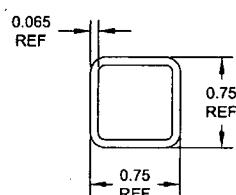
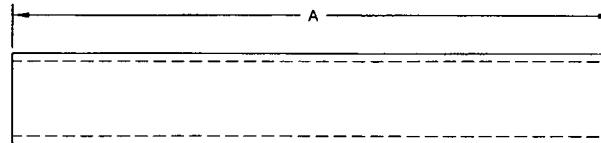
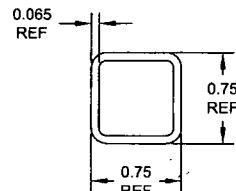
SAT 09-07-09 ①

8 7 6 5 4 3 2 1

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

W
SO129



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.760W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

RELEASED
08-06-21/W

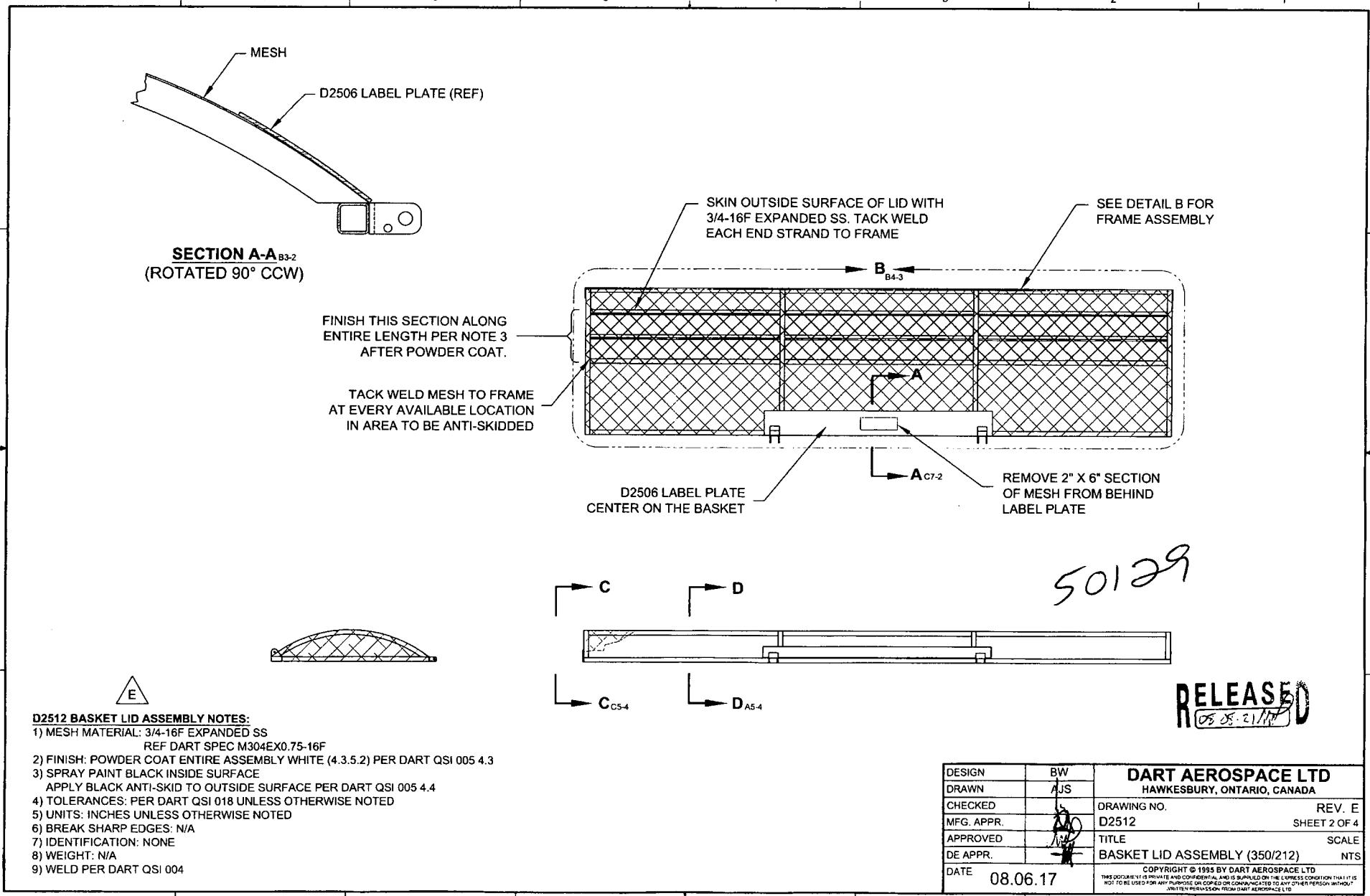
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

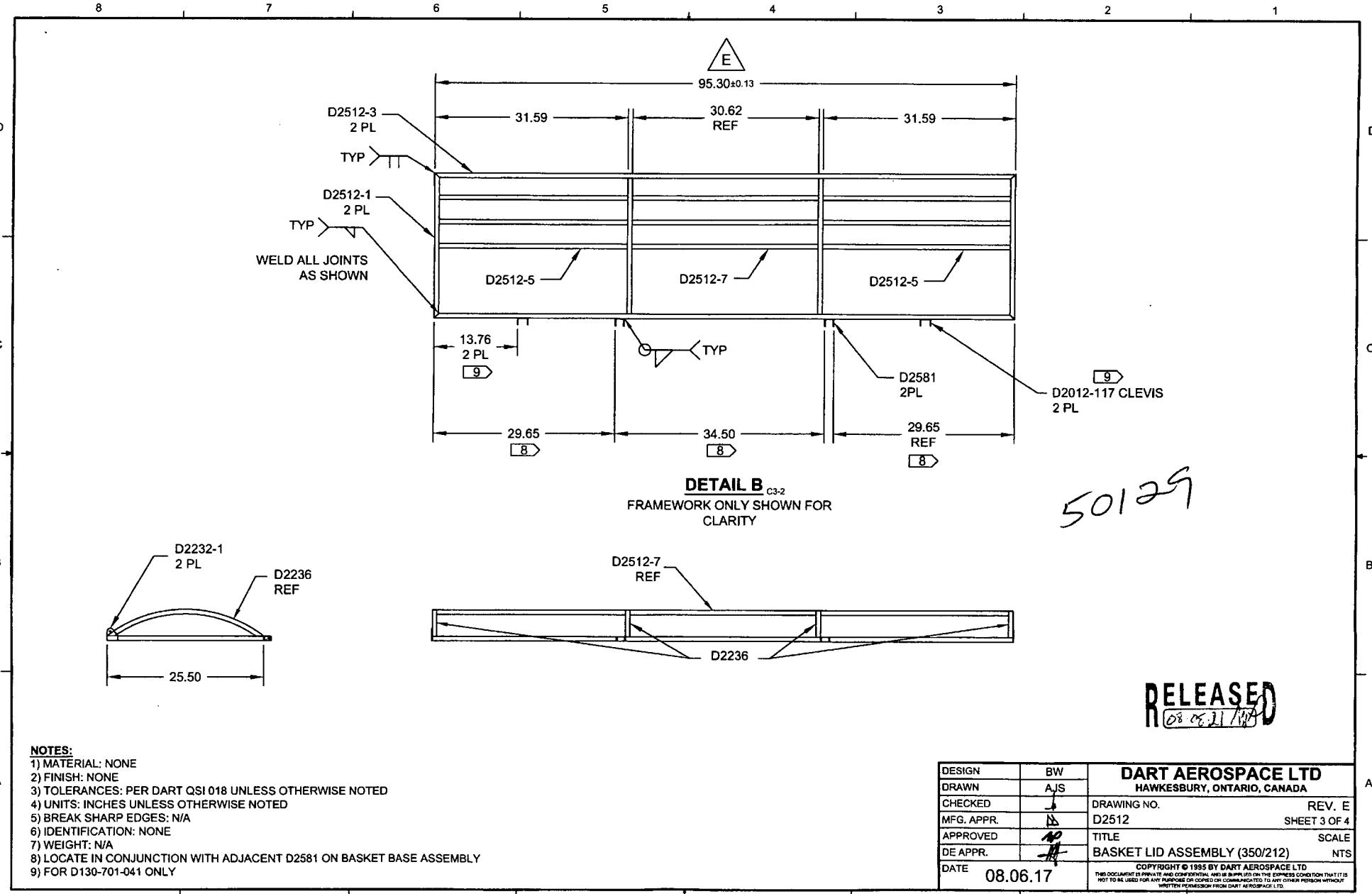
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. REV. E	
MFG. APPR.		D2512 SHEET 1 OF 4	
APPROVED		TITLE SCALE	
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS	
DATE	08.06.17	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

6 5 4 3 2 1

3 2 1





DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. E
MFG. APPR.		DRAWING NO.
APPROVED		2512
DE APPR.		SHEET 3 OF 4
DATE	08.06.17	TITLE
		SCALE
		BASKET LID ASSEMBLY (350/212)
		NTS

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